

5/06

SPCIT

DART AEROSPACE LTD	Work Order:	22170 A
Description: Wearplate	Part Number:	D2577-3
Dwg: D2577 Rev. E	Qty:	50 38
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	HJ	05.01.12	50
2	PG	Issue P/O: 2007409 Email or Ship DXF file to vendor Laser Cut per Dwg D2577 flat pattern D2577-101 Material release note required	U	05.06.18	50
3	RG	Receive and Inspect for transit damage Ensure that material release note is attached	CZ	05/01/31	50
4	QC6	Inspect dimensions per template D2577-101T1	2	05-04-21	50
5	GB	Deburr if necessary	N/A		
6	GB	Form on brake as per Dwg D2577 using DT8155 and DT8178 Identify as D2577-3	2	05.4.21	50
7	QC5	Inspect work to Step 6	HA	05/04/21	50
8	WS	Weld hard surface using DT8308A & DT838B as per Dwg D2577 <u>Qty</u> <u>Description</u> <u>Batch</u> M16901 A/R 7560 Hardcoat Rod M16234	HL	05/04/25	38
9	QC9	Inspect weld	HA	05/04/25	38
10	FP	Powder Coat Grey (Ref.4.3.5.6) per QSI 005 4.3	HL	05 04 26	38
11	QC3	Inspect Powder Coat	CZ	05/04/26	38
12	FP	Identify and Stock	HL	05 04 26	38
13	AC	Cost / part 25.94	545	05.04.27	38
14	DC	Close W/O 25.93 Inspect Level 21	HJ	05.04.26	38

Rev	Date	Change	Revised By	Approved
A	96.08.20	New Issue		
B	98.04.15	Changed finish detail, changed forming sub-contractor	KB	
C	99.02.02	Added inspection levels, Jig numbers	DM	
D	00.10.02	Reformat	EC	
E	01.06.08	Powder coat in house and went back to laser cut.	EC	
F	02.09.24	Re-format; Incorporated D2577-101-13	KJ RF	

RELEASED
02/10/02 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 12, 2005
01:18 pm

Work Order No : 0022170
Project Name : D2577-3
Project For : WK506
Work Order Type : Main
Main WO Number :
House Part Number : D2577-3
Description : Wearplate Aft
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 01-10-05
Est Finish Date : 02-07-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



NEW ZEALAND
STEEL

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Fax: (09) 3755 8559 Telex: 24826

TEST CERTIFICATE

Ref: 322M/1122

CUSTOMER	Wilkinson	P3010A01001	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC065404
CUSTOMER Q/N	90-ZIN-628		PRODUCT	COIL WIRE COIL	PAGE	1 of 1
MILL Q/N	357274		DIMENSIONS	0.155" x 48" x Coil	DATE	08 April 2003

MILL ON		357274		DIMENSIONS														TOLERANCES														MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)														1
				CHEMICAL COMPOSITION PERCENT																																										
PACK NUMBER		HEAT No		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N	CE	BEND	YIELD	T.S.	%ELONG	HARDNESS	LENGTH																					
				x100			x1000											x10000				x100		180°	G.L. =	HRB	()	(feet)																		
R9-404632-00		622644		4	TR	17	12	16												Good				47	1539																					
R9-404633-00		622644		4	TR	17	12	16												Good				47	1512																					
R9-404634-00		622652		4	TR	20	12	14												Good				50	1588																					
R9-404635-00		622652		4	TR	20	12	14												Good				50	1568																					
R9-404636-00		622652		4	TR	20	12	14												Good				48	1506																					
R9-404637-00		622652		4	TR	20	12	14												Good				48	1499																					

YIELD	GAUGE LENGTH (G.L.)				PLASTIC STRAIN RATIO (r)				IMPACT TEST				CARBON EQUIVALENT VALUE (CE)			
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"		(A)=0	(C)=45			(A)=10mm x 10mm	(C)=5mm x 5mm			(A)=C+Mn/8			(C)=C+Mn/5+Si/24
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65 t So	(F)=8"		(B)=100	(D)=10*(10+2/45) (4)			(B)=7.5mm x 10mm	(E)=5mm x 10mm			(B)=C+Mn/5+(Cr+V+Mo)/5+(Cu+Ni)/15			(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST

16 ga crms

2003 14:53 FAX 604 324 0075

WILKINSON STEEL

2003

